

Work Order ID- 106530

Friday, September 06, 2013 10:32:22 AM

106530

UPDATE
IN
OFFSHORE

Page 1

Item ID: D350-636-215 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Deluxe Skidtube LH Aerazur / Apical Cylindrical Float Compatible
 Start Date: 9/5/2013 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/13/2013 Req'd Qty: 1.00 *1* Customer:
 Reference: ECN 13-535

Approvals: Process Plan: MF Date: 13-9-6 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-636	J								

170

0.00

170

Packaging

Packaging

Memo

0.00

PULL FROM STOCK D350-636-215 X 1 B91245 106530

REMOVE OLD PAPERWORK AND REPLACE WITH NEW

ADD 1 X D3456-1 TO KIT AND UPDATE TO CHANGE 005

ID AND STOCK UNDER NEW BATCH NUMBER

Handwritten signature and date: 9/17/13

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Quality Control

Memo

0.00

Work Order ID 106530

Friday, September 06, 2013 10:32:22 AM

106530UPDATE
IN
OFFSTORE

Page 1

Item ID: D350-636-215 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Deluxe Skidtube LH Aerazur / Apical Cylindrical Float Compatible
Start Date: 9/5/2013 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/13/2013 Req'd Qty: 1.00 ***1*** Customer:
Reference: ECN 13-535

Approvals: Process Plan: MF. Date: 13-9-6 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D350-636	J

170

0.00

170

Packaging

Memo

0.00

Packaging

PULL FROM STOCK D350-636-215 X 1 B91245

REMOVE OLD PAPERWORK AND REPLACE WITH NEW

ADD 1 X D3456-1 TO KIT AND UPDATE TO CHANGE 005

ID AND STOCK UNDER NEW BATCH NUMBER

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Work Order ID 106530

Friday, September 06, 2013 10:32:22 AM

106530

Page 2

Item ID: D350-636-215

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Deluxe Skidtube LH Aerazur / Apical Cylindrical Float Compatible

Stop ***NS2***Start Date: 9/5/2013 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/13/2013 Req'd Qty: 1.00 ***1***

Customer:

Reference: ECN 13-535

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
185	Identify as per dwg & Stock Location: _____	0.00							
185									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

Offshore
update
ME
13-9-18

MC 13-09-18

ME
13-9-18

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Page 1

Work Order ID: 106530

Parent Item: D350-636-215

Start Date: 9/5/2013

Required Date: 9/13/2013

Parent Item Name: Deluxe Skidtube LH Aerazur / Apical Cylindrical Float Compatible

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.10.04 new issue DD verf:EC IPP Rev:B 11.04.14 ecn11-553
DD verf:EC IPP Rev:C 112.04.16 AS PER ECN 12-542 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3456-1 Washer		Manufactured	No				Each	131.0000		1			

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST047	124	
103539	50	
103787	25	
80252	1	
85223	1	
89237	6	
96570	21	
99338	20	

D350-636-215

Manufactured

No

Each

0.0000

1

Deluxe Skidtube LH Aerazur / Apical Cylindrical Float Compatible

1 x 91245
MF
13-9-6.

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

REVISION RECORD

Revision	Issue Date	Description
A	98.04.16	New Issue
B	98.09.02	Change blade bolt to AN8-16A
C	98.11.19	Add -013/-014 skid tubes for Aircruiser compatibility
D	06.01.03	Add compatibility with Apical Tri-bag Floats and Apical Cylindrical Floats
E	07.05.15	Change wearplates to stainless steel; Re-organize installation procedure.....pg. 4-7; Add Dart D350-748 crosstube compatibility.....pg. 3; Incorporate DSI 9343.....pg. 6,13; Replace D350-636-041 kit with -043 kit.....pg. 12,13; Item 17 now D3631-1 Washer.....pg. 12; Item 18 now ALS4-1032-225.....pg. 12; Removed * from items 9-12.....pg. 12; Add rubber gaskets, item 23B, 24B, 25B.....pg. 13; Remove NAS1515H3L washers from the wearshoes.....pg. 13
F	08.08.14	Add note to use Antiseize compound.....pg. 5, 8; Add reference to DSI 9413;.....pg. 6-7; Add D350-636-011/-012/-013/-014 at CHG 004 drawing.....pg. 10; Add Parts List for D350-636-011/-012/-013/-014 at CHG 004.....pg. 17
G	10.07.12	Incorporated DSI 9456, DSI 9457, DSI 9490 Fixed typo on pg. 3, 355A41-2002-03 changed to 355A41-2001-03
H	10.07.26	Add D350-636-015/-016/-017/-018/-047 kits.....pg. 13; Add Parts List for D350-636-015/-016/-017/-018/-047.....pg. 29; Add D350-636-215/-216/-217/-218 Kits.....pg. 13; Add Parts List for D350-636-215/-216/-217/-218.....pg. 31
I	10.10.25	D4170-3 Spacer was D4170-1pg. 10,30; Drill size for D4170-3 Spacer is Ø0.453" (was Ø0.313 for -1).....pg. 10
J	13.03.01	Incorporate DSI 9570.....pg. 3; Ø0.633" was Ø0.625" section 3.10.1.....pg.10; Revised section R-Rpg. 17; Update Weight and Balance for D350-636-047.....pg. 22; Add 1X D3456-1 to D350-636-109.....pg. 28

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Revision: J

Date: 13.03.01

List Lots

September-05-13 11:19:21 AM

Page 1 of 1

Criteria : Item ID: 'D350-636-215', 'D350-636-216', 'D350-636-217', 'D350-636-218'

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	All Locations Lot Code	All Warehouses Type Code	All Quantity	Comments
D350-636-215 Deluxe Skidtube LH Aerazur / Apical Cylindrical Float Compatible	Main Warehouse FG	91248 #106529	6/05/13	1.0000		QC21	CHG004		Angle of 1.44*
	Main Warehouse FG072	97328 #106529	5/10/13	1.0000		QC21	CHG004		Angle of 2.73* . Ship Local
	OFFSHORE FG	85190 #106529	5/22/13	1.0000		QC21	CHG004		
	OFFSHORE FG	91245 #106530	5/10/13	1.0000		QC21	CHG004		
	OFFSHORE FG	91246 #106531	6/05/13	1.0000		QC21	CHG004		
Total:				5.0000					
D350-636-216 Deluxe Skidtube RH Aerazur / Apical Cylindrical Float Compatible	Main Warehouse FG073	91252 #106532	5/10/13	1.0000		QC21	CHG004		Angle of 2.56* . Ship local
	OFFSHORE FG	85193 #106533	5/22/13	1.0000		QC21	CHG004		
	OFFSHORE FG	91249 #106534	5/10/13	1.0000		QC21	CHG004		
	OFFSHORE FG	91250 #106535	6/05/13	1.0000		QC21	CHG004		
Total:				4.0000					
D350-636-218 Deluxe Skidtube RH Air Cruiser / Apical Tri-Bag Float Compatible	Main Warehouse FG073	91253 #106536	5/10/13	1.0000		QC21	CHG004		Angle of 1.98*
Total:				1.0000					

10/11/14
106536